



10/26/00

10-27-00

A

PTO/SB/05 (4/98)

Approved for use through 09/30/2000 OMB 0651-0032

Patent and Trademark Office: U.S. DEPARTMENT OF COMMERCE

Please type a plus sign (+) inside this box → ☐

Under the paperwork Reduction Act of 1995, no persons are required to respond to a collection of information unless it displays a valid OMB control number

UTILITY		Attorney Docket No.		5544/301	
PATENT APPLICATION TRANSMITTAL		First Inventor		Phillip Koehler, et al.	
		Title		Cutting and Laminating Apparatus for Producing Reinforced Web	
		Express Mail Label No.		EM388584166US	
(Only for new nonprovisional applications under 37 C.F.R. § 1.53(b))		ADDRESS TO:		Assistant Commissioner for Patents Box Patent Application Washington DC 20231	
APPLICATION ELEMENTS					
See MPEP chapter 600 concerning utility patent application contents.					
1. <input checked="" type="checkbox"/> *Fee Transmittal Form (e.g. PTO/SB/17) (Submit an original and a duplicate for fee processing)		5. <input type="checkbox"/> Microfiche Computer Program (Appendix)			
2. <input checked="" type="checkbox"/> Specification Total Pages (20) (preferred arrangement set forth below)		6. Nucleotide and/or Amino Acid Sequence Submission (If applicable, all necessary)			
- Descriptive title of the invention		a. <input type="checkbox"/> Computer Readable Copy			
- Cross References to Related Applications		b. <input type="checkbox"/> Paper Copy (identical to computer copy)			
- Statement Regarding Fed sponsored R & D		c. <input type="checkbox"/> Statement verifying identity of above copies			
- Reference to Microfiche Appendix					
- Background of the Invention					
- Brief Summary of the Invention					
- Brief Description of the Drawings (if filed)					
- Detailed Description					
- Claim(s)					
- Abstract of the Disclosure					
3. <input checked="" type="checkbox"/> Informal Drawing(s) (35 U.S.C. 113) Total Sheets (12)					
4. <input checked="" type="checkbox"/> Oath or Declaration (unexecuted)					
a. <input type="checkbox"/> Newly executed (original or copy)					
b. <input type="checkbox"/> Copy from a prior application (37 C.F.R. § 1.63(d))					
i. <input type="checkbox"/> DELETION OF INVENTOR(S) Signed statement attached deleting inventor(s) named in the prior application, see 37 C.F.R. §§ 1.63(d)(2) and 1.33(b).					
*NOTE FOR ITEMS 1 & 13: IN ORDER TO BE ENTITLED TO PAY SMALL ENTITY FEES, A SMALL ENTITY STATEMENT IS REQUIRED (37 C.F.R. § 1.27), EXCEPT IF ONE FILED IN A PRIOR APPLICATION IS RELIED UPON (37 C.F.R. § 1.28)					
		ACCOMPANYING APPLICATION PARTS			
		7. <input type="checkbox"/> Assignment Papers (cover sheet & document(s))			
		8. <input type="checkbox"/> 37 C.F.R. § 3.73(b) Statement <input checked="" type="checkbox"/> Power of Attorney (when there is an assignee)			
		9. <input type="checkbox"/> English Translation Document (if applicable)			
		10. <input type="checkbox"/> Information Disclosure Statement (IDS)/PTO-1449 <input type="checkbox"/> Copies of IDS Citations			
		11. <input type="checkbox"/> Preliminary Amendment			
		12. <input checked="" type="checkbox"/> Return Receipt Postcard (MPEP 503) (Should be specifically itemized)			
		13. <input type="checkbox"/> *Small Entity <input type="checkbox"/> Statement filed in prior application Statement(s) Status still proper and desired (PTO/SB/09-12)			
		14. <input type="checkbox"/> Certified Copy of Priority Document(s) (if foreign priority is claimed)			
		15. <input checked="" type="checkbox"/> Other: Checks in the amount of \$764.00 and \$314.00			
16. If a CONTINUING APPLICATION, check appropriate box, and supply the requisite information below and in a preliminary amendment:					
<input type="checkbox"/> Continuation <input type="checkbox"/> Divisional <input type="checkbox"/> Continuation-in-part (CIP) of prior application no.: _____					
Prior application information: Examiner: _____ Group / Art Unit: _____					
For CONTINUATION or DIVISIONAL only: The entire disclosure of the prior application, from which an oath or declaration is supplied under Box 4b, is considered a part of the disclosure of the accompanying continuation or divisional application and is hereby incorporated by reference. The incorporation can only be relied upon when a portion has been inadvertently omitted from the submitted application parts.					
17. CORRESPONDENCE ADDRESS					
<input type="checkbox"/> Customer No. or Bar Code Label or <input checked="" type="checkbox"/> Correspondence address below					
(insert Customer No. or Attach bar code label here)					
Address Oppenheimer Wolff & Donnelly LLP 45 South Seventh Street 3400 Plaza VII					
City	Minneapolis	State	Minnesota	Zip Code	55402
Country	USA	Telephone	612-607-7387	Fax	612-607-7100
Name (Print/Type)	Craig J. Lervick	Registration No. (Attorney/Agent)	35,244		
Signature		Date	October 26, 2000		

Under the Paperwork Reduction Act of 1995, no persons are required to respond to a collection of information unless it displays a valid OMB control number.

**FEE TRANSMITTAL
for FY 2001**

Patent fees are subject to annual revision.

Complete if Known

Application Number	
Filing Date	October 26, 2000
First Named Inventor	Phillip Koehler
Examiner Name	
Group Art Unit	
Attorney Docket No.	5544/301

TOTAL AMOUNT OF PAYMENT	(\$)	1078.00
-------------------------	------	---------

METHOD OF PAYMENT

1. ☒ The Commissioner is hereby authorized to charge indicated fees and credit any overpayments to:

Deposit Account Number	15-0627
Deposit Account Name	Oppenheimer, Wolff & Donnelly LLP

☒ Charge Any Additional Fee Required Under 37 CFR 1.16 and 1.17

☐ Applicant claims small entity status See 37 CFR 1.27

2. ☒ Payment Enclosed:

☒ Check ☐ Credit card ☐ Money Order ☐ Other

FEE CALCULATION**1. BASIC FILING FEE**

Large Entity Code	Small Entity Code	Fee (\$)	Fee Description	Fee Paid	
101	710	201	355	Utility filing fee	710.00
106	320	206	160	Design filing fee	
107	490	207	245	Plant filing fee	
108	710	208	355	Reissue filing fee	
114	150	214	75	Provisional filing fee	

SUBTOTAL (1) (\$)

2. EXTRA CLAIM FEES

Total Claims	Extra Claims	Fee from below	Fee Paid
36	-20** = 16	18	288.00
4	-3** = 1	80.	80.00
Multiple Dependent			

Large Entity Code	Small Entity Code	Fee (\$)	Fee Description
103	18	203	9
102	80	202	40
104	270	204	135
109	80	209	40
110	18	210	9

SUBTOTAL (2) (\$)

**or number previously paid, if greater; For Reissues, see above

FEE CALCULATION (continued)**3. ADDITIONAL FEES**

Large Entity Code	Small Entity Code	Fee (\$)	Fee Description	Fee Paid	
105	130	205	65	Surcharge - late filing fee or oath	
127	50	227	25	Surcharge - late provisional filing fee or cover sheet	
139	130	139	130	Non-English specification	
147	2,520	147	2,520	For filing a request for ex parte reexamination	
112	920*	112	920*	Requesting publication of SIR prior to Examiner action	
113	1,840*	113	1,840*	Requesting publication of SIR after Examiner action	
115	110	215	55	Extension for reply within first month	
116	390	216	195	Extension for reply within second month	
117	890	217	445	Extension for reply within third month	
118	1,390	218	695	Extension for reply within fourth month	
128	1,890	228	945	Extension for reply within fifth month	
119	310	219	155	Notice of Appeal	
120	310	220	155	Filing a brief in support of an appeal	
121	270	221	135	Request for oral hearing	
138	1,510	138	1,510	Petition to institute a public use proceeding	
140	110	240	55	Petition to revive - unavoidable	
141	1,240	241	620	Petition to revive - unintentional	
142	1,240	242	620	Utility issue fee (or reissue)	
143	440	243	220	Design issue fee	
144	600	244	300	Plant issue fee	
122	130	122	130	Petitions to the Commissioner	
123	50	123	50	Petitions related to provisional applications	
126	240	126	240	Submission of Information Disclosure Stmt	
581	40	581	40	Recording each patent assignment per property (times number of properties)	
146	710	246	355	Filing a submission after final rejection (37 CFR § 1.129(a))	
149	710	249	355	For each additional invention to be examined (37 CFR § 1.129(b))	
179	710	279	355	Request for Continued Examination (RCE)	
169	900	169	900	Request for expedited examination of a design application	

Other fee (specify) _____

* Reduced by Basic Filing Fee Paid

SUBTOTAL (3) (\$)

SUBMITTED BY**Complete (if applicable)**

Name (Print/Type)	Craig J. Lervick	Registration No. (Attorney/Agent)	35,244	Telephone	612-607-7387
Signature		Date	10-26-00		

WARNING: Information on this form may become public. Credit card information should not be included on this form. Provide credit card information and authorization on PTO-2038.

Burden Hour Statement: This form is estimated to take 0.2 hours to complete. Time will vary depending upon the needs of the individual case. Any comments on the amount of time you are required to complete this form should be sent to the Chief Information Officer, U.S. Patent and Trademark Office, Washington, DC 20231. DO NOT SEND FEES OR COMPLETED FORMS TO THIS ADDRESS. SEND TO: Assistant Commissioner for Patents, Washington, DC 20231.

UTILITY

IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant : Phillip Koehler, et al.
Ser. No. :
Filed :
Title : CUTTING AND LAMINATING
APPARATUS FOR PRODUCING
REINFORCED WEB
Docket No : 5544/301

CERTIFICATE OF EXPRESS MAIL

Date of Deposit: October 26, 2000

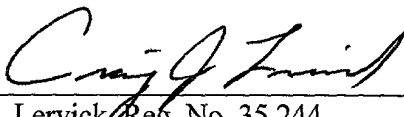
Express Mail Certificate No.: EM388584166US

I hereby certify that these papers and fee(s) are being deposited with the United States Postal Service as express mail in an envelope addressed to: Box Patent Applications, Assistant Commissioner for Patents, Washington, D.C. 20231

Paper(s) Enclosed:

- ☒ Transmittal Letter AND Fee Transmittal
- ☒ Checks in the amount of \$764.00 and \$314.00
- ☒ Specification 12 page(s)
- ☒ Claims 7 page(s)
- ☒ Abstract 1 page(s)
- ☒ Drawings 12 page(s) INFORMAL
- ☒ Declaration & Power of Attorney (unsigned) 2 page(s)
- ☒ Certificate of Express Mail
- ☒ Postcard

By:


Craig J. Lervick, Reg. No. 35,244
OPPENHEIMER WOLFF & DONNELLY
Plaza VII, Suite 3400
45 South Seventh Street
Minneapolis, Minnesota 55402
Telephone: (612) 607-7387

CUTTING AND LAMINATING APPARATUS FOR PRODUCING REINFORCED WEB

BACKGROUND OF THE INVENTION

5 The present invention relates to manufacturing equipment and manufacturing processes utilizing a continuous web of material. For example, the present invention may be used to reinforce portions of flexible packaging material. More specifically, the present invention relates to a system and process for reinforcing portions of a web, which can be supplied to subsequent processing equipment and operations.

10 Many web-based processes presently exist for various types of manufacturing. In each of these processes, bulk raw materials are supplied to various systems in a web format for further manipulation or processing. These bulk supplies of material often take the form of very large rolls which can then be unwound appropriately to create a web. More specifically, the material is unwound and fed into the processing machines, forming a web. In the packaging industry, these webs often take the form of plastics which will be formed into bags, containers or other enclosures. For example, the supply web may be wrapped around existing products, and then sealed at three or four edges to completely enclose the particular product.

15 Web manufacturing processes are typically very desirable due to the high speeds and efficiencies which can be achieved. For example, it is fairly easy to move material webs along a desired path using various rollers, including handling rollers and drive rollers. Similarly, in-line cutters and sealers can very easily be incorporated into these manufacturing processes as well. Because these operations are being done "in line", they can be very quickly accomplished. It is fairly well known, however, that operations transverse to the web are less easily carried out and more complicated.

20 In these web-based processes, the actual material being used will dictate the capabilities and constraints of possible activities. Ideally, the material web is flexible and relatively strong. Consequently, material can be pulled through various rollers and various manufacturing apparatus without the fear of breaking or severing. Conversely, if a material is too rigid, it does not easily move through the manufacturing process, and is not easily manipulated. Further complications are encountered when this relatively heavy or rigid material must be cut or severed in any way. More specifically, it is difficult to achieve precise cuts of this more rigid material,

especially when attempting to cut in a direction transverse to the web. Further, when working with a web that is quite wide, these transverse cuts become fairly long, which creates significant difficulties. Existing cutting mechanisms are not capable of precisely creating these long cross-web cuts.

Another complication of web-based manufacturing processes is the necessity to reinforce certain portions of the web. In particular, it may be desirable to reinforce only certain portions of the web, due to later operations that may be performed on only a portion of the web. For example, it may be desirable to reinforce the seal region where various layers of material are joined together. Reinforcing only a portion of the web introduces positioning and alignment complications however. As can be easily appreciated, this reinforcement operation becomes particularly difficult when it must be positioned transverse to the web. Additionally, the small strips of reinforcing material typically used are often difficult to handle.

One approach to reinforcing web at predetermined locations is to utilize a preformed roll of reinforcing material and applying it at appropriate locations. This roll of reinforcing material is specifically configured for this purpose and is typically much smaller than the actual web itself. For example, one typical application may require a web approximately 2 to 4 feet wide, but may require reinforcing strips only 1 inch wide. When purchased as exclusive rolls of reinforcing material, these rolls are specifically produced in the desired narrow width. While this affords some manufacturing efficiencies by utilizing pre-sized reinforcing material, additional cost is inherently added to the process. These prefabricated "narrow" rolls of reinforcing material are necessarily more expensive than similar product purchased in larger bulk format. Consequently, it would be desirable to utilize a more cost effective method of manufacturing which utilizes larger bulk materials. This is particularly true when the reinforcing material itself is a heavier, more expensive product to begin with.

In addition to the additional cost, when incorporating cross web reinforcement using these narrow rolls, the process is inherently slow. Material must be moved in a direction transverse to the web, rather than in line with the web. As with all web manufacturing, it is highly desirable to have all operations moving along with the web.

While the desirability of using bulk reinforcing materials may appear obvious, this does introduce more significant cutting and manipulating operations, as outlined above. Present day

equipment is not capable of efficiently producing the necessary reinforcing strips from bulk webs of material.

SUMMARY OF THE INVENTION

In order to provide an efficient and cost effective method for reinforcing selected portions of a web, the present invention provides a mechanism which utilizes a large format supply of reinforcing material to selectively reinforce portions of a primary web. In order to accomplish this reinforcement the present invention includes a primary web handling system and a secondary web handling system, a cross web shear, a strip handling system and a laminating device. The primary web handling system handles the main web of packaging material, or primary web, which will be reinforced for later operations.

In order to provide this reinforcement, reinforcing strips are produced from the secondary web and then laminated to the primary web. Specifically, the secondary supply web provides reinforcing material to the cross web shear which cuts the secondary web into reinforcing strips of predefined width. Subsequently, this strip of reinforcing material is provided to a handling mechanism for moving the reinforcing strip to a predetermined location for attachment to the primary web. The laminating device is then utilized to attach this reinforcing strip.

To accomplish the complicated task of cross web cutting, the cross web shear of the present invention is uniquely configured. The cross web shear includes a radiused blade and a cam follower structure in order to initiate a single point cutting action. The cam follower structure, and all related driving devices, move the blade through a predetermined rocking type motion. By using the radiused cutting edge of the blade in this rocking type motion, only a single point of the blade is actually cutting at any particular point in time. This configuration allows for precise cross web cutting of the reinforcing material itself into the desired reinforcing strips.

In order to appropriately reinforce the primary web, the handling mechanism includes a vacuum manifold structure to grab the reinforcing strip and move it to its desired location. In one particular application, this reinforcing strip is relatively narrow and small compared to the primary web. Consequently, moving and handling of this component is complicated. This is especially true when desired precision is necessary. The vacuum manifold is capable of precisely capturing the reinforcing strip and moving it via an attached positioning device. The

positioning device is then capable of moving the manifold to a desired location which is adjacent the laminating device. Lamination of the reinforcing strip can then easily be accomplished.

It is an object of the present invention to create a device for reinforcing a primary web at predetermined locations.

5 It is a further object of the present invention to provide a cross web shear capable of cutting reinforcing material into reinforcing strips of a desired size. The cross web shear fabricates these reinforcing strips from a bulk supply web and incorporates precision cuts to control the size and configuration of the reinforcing strip itself.

10 It is a further object of the present invention to create reinforcing strips from a bulk stock of reinforcing material. This reinforcing material supply can be provided in a secondary web format for efficient and cost effective creation of reinforcing strips.

15 It is a further object of the present invention to create reinforcing strips using a cross web shear, appropriately position these reinforcing strips adjacent to a primary web, and attach these reinforcing strips to the primary web. Consequently, the primary web is reinforced at predetermined locations to easily accommodate further operations.

BRIEF DESCRIPTION OF THE DRAWINGS

Further objects and advantages of the present invention can be seen by reading the following detailed description in conjunction with the drawings in which:

20 Figure 1 is a schematic illustration of the cutting and laminating device;

Figure 2 is a more detailed illustration of the actual cutting apparatus, and the sealing apparatus;

Figure 3 is a side cross-sectional view of the cross web shear and the strip handling manifold;

25 Figure 4 is a perspective view of the major components of the cutting and laminating device;

Figures 5A-5E are segmented drawings illustrating the various positions taken by the shear blade during its stroke;

Figure 6 is a cross-sectional diagram illustrating the strip handling manifold;

30 Figure 7 is a second cross-sectional diagram of the strip handling manifold; and

Figure 8 is a flow chart showing the operating steps of the cutting and laminating apparatus of the present invention.

DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS

5 As mentioned above, the present invention relates to manufacturing equipment for use in web based manufacturing operations. More specifically, the apparatus and methods of the present invention provide for the reinforcing of a primary web of material which can then be supplied to further manufacturing operations. For example, the reinforced web may be used to produce other products, such as bags or other containers for holding and containing other materials. In its most common environment, the apparatus and system of the present invention will be a component of a larger manufacturing operation and achieves the step of reinforcing the web material for use in further operations.

15 Referring now to Figures 1 and 4 there is shown schematic and perspective illustrations of the cutting and laminating apparatus (10) of the present invention. Mounted within the cutting and laminating apparatus is a primary supply web (12) and a secondary supply web (14). In this embodiment, the primary supply web contains the material which will be reinforced and later fed to subsequent manufacturing operations. Secondary supply web contains the material that will be used for reinforcing the primary supply web. For example, primary supply web (12) may include a large roll of oriented polypropylene, high density polyethylene, metalized oriented polypropylene, or other standard packaging materials. Similarly, secondary supply web may be a roll of label film, barrier film, blister forming material, adhesive material, tear strip material, or other additional films/material. Alternatively, secondary supply web (14) may be the same as the primary supply web (with the same or differing gauges), depending on the particular needs of the application.

25 The output from primary supply web (12) is fed through a series of dancer rollers (16) which operate as a supply holding buffer. Further, these rollers help to manipulate and straighten the material from primary supply web (12). Next, the primary supply web is directed past a registration eye (18) in order to insure a proper alignment and positioning of the web. The primary web (12) is then directed above laminating device (20). As will be further described, laminating device (20) is operable to laminate the reinforcing strip to the primary web at appropriate positions and times.

This movement of the web is controlled by a primary feed roller (24) which controls all movement of the primary web. Primary feed roller (24) is a servo controlled roller which operates in conjunction with a pinch roller (26) to accurately control any movement on the primary web. Downstream from the primary feed roller is an output buffer (28), shown here as a pair of rollers.

As further shown in Figure 1, the secondary supply web (14) supplies material for web reinforcement. More specifically, the material from secondary supply web is first fed through a series of dancer rollers (32), which again operate as a supply buffer. From these dancer rollers (32) the material is provided to a secondary feed roller (34) which cooperates with a second pinch roller (36) to control the movement of the secondary web. The secondary feed roller (34), directs appropriate portions of the secondary web (14) to a cross web shear (40) which cooperates with an applicator head (50) to produce reinforcing strips. As will be further described, secondary feed roller (34) positions the secondary web (14) adjacent to cross web shear (40) such that a reinforcing strip can be cut from the secondary web (14). Cross web shear (40) will then be actuated to shear the reinforcing strip from secondary web (14). Applicator head (50) is appropriately aligned adjacent cross web shear (40) so that it can hold and reposition the reinforcing strip appropriately. More specifically, applicator head (50) will move the reinforcing strip to a position adjacent primary web (12) and laminating device (20). Laminating device (20) is then capable of laminating the reinforcing strip to the primary web at the appropriate location.

Many of the various components shown on Figure 1 require a coordinated control to insure proper operation of the cutting and laminating apparatus (10). For example, primary feed roller (24) and secondary feed roller (34) must both be appropriately controlled to position the primary web and the secondary web (respectively) so that proper operations can be formed on those materials. Further, cross web shear (40) must be appropriately controlled to provide the cutting/shearing desired. Similarly, applicator head (50), laminating device (20) and other components require this centralized control. Controller (30) is thus coupled to all necessary components of cutting and laminating apparatus (10) in order to comprehensively control its operation. As will be clearly understood by those skilled in the art, controller (30) may be a dedicated controller coupled to each specific apparatus, or may be a centralized controller, coupled to various individual device controllers on each of the products themselves.

As can be seen in Figure 1, one embodiment of the applicator head (50) includes four separate manifold heads (52), each of which are capable of holding and positioning a reinforcing strip. In this particular embodiment, applicator head (50) is rotated approximately 90 degrees to move the reinforcing strip from its cutting location to its sealing location. As will be further
5 illustrated, other configurations are possible for this arrangement, depending on various equipment layouts and process needs. For example, different numbers of manifold heads could be used, or a non-rotational movement path could be followed.

Referring now to Figures 2 and 3 there are shown more detailed diagrams illustrating the configuration of cross web shear (40), applicator head (50) and various components thereof.

10 Cross web shear (40), generally includes a mounting block (42) which is attachable to the framework of the cutting and laminating apparatus (10). Further, cross web shear includes a shear blade (44) and a web support (46). Also included is a slide plate (48) designed to support and accommodate the easy movement of shear blade (44). Web support (46) includes a support
15 blade (47) which cooperates with shear blade (44) to perform the necessary cutting of secondary web (14).

As can be seen, cross web shear (40) is positioned adjacent to applicator head (50). More specifically, cross web shear (40) has a material feeding gap (54) which exists immediately above web support (46) and below mounting block (42). Secondary web (14) passes through gap (54) and is appropriately positioned for shearing. As the material extends through gap (54), it
20 will pass directly above applicator manifold (52). This allows applicator manifold (52) to hold the extending portion of secondary web (14) during the shearing process.

Cooperating with applicator manifold (52) is a holding clamp (60) which is configured to help hold the reinforcing strip in place when cut. Referring specifically to Figure 3, a laminating strip (64) is shown after being cut and while being held in place by holding clamp (60) and
25 applicator manifold (52). As can be seen, applicator manifold (52) includes a number of internal vacuum chambers (56) which are fluidly attached to similar vacuum chambers (58) in rotating block (51). Together, each of these vacuum chambers cooperate to hold reinforcing strip (64) on an upper surface of applicator manifold (52). Various vacuum controls (not shown) are utilized to control this vacuum signal structure.

30 Referring specifically to Figure 2, more details are shown regarding the holding clamp (60) and related mechanisms. As can be seen, holding clamp (60) is moveable between a first

position and a second position to allow the feeding and holding of reinforcing strip (64).

Holding clamp (60) is configured as an elongated tab which is attached to a rotation block (68) which is rotatable round about a central axis (70). An actuating tab (72) extends in a direction opposite of holding clamp (60). Attached to one end of actuating tab (72) is a tab actuating cylinder (74). The opposite end of actuating cylinder (74) is attached to a holding frame (76). This holding frame (76) is then rigidly attached to the framework of cutting and laminating apparatus. In operation, actuating cylinder (74) is moveable between multiple positions, which cause related movement of holding clamp (60). Through this configuration, holding clamp (60) can be moved between its holding position and a feeding position which allows secondary web (14) to be fed through a feeding gap thus extending above applicator manifold (52).

Holding clamp (60) cooperates with applicator head (50) in order to appropriately hold the extending portion of secondary web (14) prior to cutting, and also hold the reinforcing strip, after sheared from the secondary web. When the secondary web is fed through cross web shear (40) it will then extend over the top of applicator manifold (52). Prior to cutting, tab actuating cylinder (74) will be actuated causing holding tab (60) to move downward (as shown in Figure 2) thus pressing secondary web (14) against the top surface of applicator manifold (52). Simultaneously, vacuum signals will be generated within applicator manifold (52), thus also pulling secondary web (14) into contact with applicator manifold (52). Once in this configuration, cross web shear (40) can then be activated causing shear blade (44) and support blade (47) to shear a portion of secondary web (14) thus creating reinforcing strip (64). By holding or capturing reinforcing strip (64)/secondary web (14) in this manner, a precision cut can be achieved by cross web shear (40).

Referring now to Figure 5 there is shown multiple positional diagrams illustrating the movement of shear blade (44). As can be seen, shear blade (44) is held against slide plate (48) via a pair of cam follower pins (140). Cam follower pins (140) are attached to a main framework (146) in order to maintain constant separation. Cam pins (140) and framework (146) follow a predetermined path during a cutting stroke. The main framework (146) is moved through this predetermined path by a cam actuator (160) which includes a pair of push rods (162). The extension of push rods (162) causes lateral movement of main framework (146) and cam pins (140). As can also be seen, a pair of guiding tracks (150) are provided in cutting blade (44) to direct its motion. As is fairly well known by those involved with cam follower mechanisms, the

movement of cam follower pins (140) causes a controlled movement of shear blade (44). In this particular embodiment, shear blade (44) goes through a generally rocking type motion in order to efficiently shear the reinforcing material of secondary web (14).

Also shown in Figure 5 is an additional cam framework (152) which is designed to prevent lateral movement of the blade when cam follower pins (140) are moved laterally. Cam framework (152) includes a cam track (154) which is in a generally vertical orientation (although not perpendicular to support blade (47)). Cooperating with cam track (154) is a blade cam follower (156). Blade cam follower (156) is attached to blade (44) and consequently moves therewith. As can be seen, blade cam follower (156), will follow cam track (154) as the main cam follower pins (140) move along their path. Further, blade cam follower (156) prevents lateral movement and further directs shear blade (44) through its desired motion.

The movement of shear blade (44) can be seen by sequentially viewing figures 5A-5E. As can be seen, shear blade (44) and framework (146) are at one end of their travel in Figure 5A. In Figure 5C, framework (146) has traveled one half of its full travel distance, thus moving shear blade to a central position. Lastly, Figure 5E shows shear blade (44) and framework (146) having completed their travel range.

By utilizing a "rocking" motion for shear blade (44), the cross web shear (40) of the present invention is able to more accurately and efficiently shear secondary web into a number of reinforcing strips. This is especially true when utilizing heavy weight material for cross web shear which does not necessarily easily cut. Often times problem are encountered in the precise cutting of this heavy weight material. The cross web shear of the present invention addresses these problems by incorporating this rocking blade motion.

In addition to the above-mentioned desirable characteristics of this rocking motion, the blade travel is also closely controlled. As shown in Figures 1, 2, 3 and 4, cross web shear (40) is located in close proximity to the applicator head (50). Consequently, the actual travel of shear blade (44) must be carefully controlled so as to allow appropriate movement of applicator head (50). Specifically, shear blade (44) cannot travel any significant distance below support blade (47), in order to avoid interference with applicator head (50). As can be seen by referring to Figures 5A-5E, shear blade (44) extends only a small amount below support blade (47) at any point in time. More significantly, the actual distance which shear blade (44) extends below support blade (47) is very carefully controlled and kept at a minimum to avoid interference with

applicator head (50). By controlling this relationship, creative flexibility is afforded in designing any related components.

Referring specifically to Figure 6 and 7, there is shown more detailed cross-sectional views of applicator head (50). More specifically, Figure 6 shows an end cross-sectional view while Figure 7 shows a side cross-sectional view. As previously mentioned, a pair of applicator manifolds (52) are attached to a central rotation block (51) to achieve the appropriate holding and positioning functions of applicator head (50). Rotation block (51) is rotatable around a central axis (80) in order to accommodate movement of the reinforcing strips. The cross web shear (40) and laminating device (20) are appropriately positioned relative to the application head (52) to accommodate this 180 degree rotational move. Referring to Figure 7, it can be seen that rotation shaft (80) is attached to a shaft drive (82) which is used to appropriately move applicator head (50) when necessary. Be understood that this is a servo controlled drive motor which is capable of precise angular positioning of the attached rotation shaft (80).

Located on an opposite end of applicator head (50) is a vacuum signal feed manifold (90) which is operatively coupled to rotation block vacuum chamber (58). Consequently, appropriate vacuum signals can be introduced at vacuum signal feed manifold (90) and then transferred to application head (50). As will be recognized, appropriate valves and vacuum supply sources can be easily attached to vacuum signal feed manifold (90). The vacuum signals are then passed to rotation block vacuum chamber (58) via a vacuum coupling (92), while also allowing applicator head (50) to be rotatable.

As previously mentioned, the reinforcing strip (64) must be attached to primary web (12) at an appropriate position. In order to accomplish this attachment, laminating device (20) is utilized. As can be seen in Figure 2, laminating device (20) includes a laminating head (100) which has an integral heating element (102). As can be appreciated, heating element (102) provides sufficient heat to a heat seal reinforcing strip (64) to primary web (12). Laminating head (100) is attached to a mounting structure (104) which in turn is attached to the piston of laminating cylinder (110). Actuating laminating cylinder (110) causes laminating head (100) to move upward, thus ultimately contacting primary web (12). Heat is then applied via heating element (102) resulting in the desired heat sealing.

Referring now to Figure 8 there shown a flow chart which describes the overall operation of cutting and laminating apparatus 10. Initially the system waits until a supply demand is

requested from upstream equipment. At step 120 a supply need is sensed at the output buffer causing the system to initiate its cycle. Next, the system simultaneously executes multiple options. First, at step 122 the bag material, or primary web, is advanced one length.

Simultaneously, reinforcing material, or secondary web material, is advanced a predetermined length. After this predetermined length has been advanced, the shear step is initiated where a reinforcing strip is created by gripping and shearing the secondary web. Next, this reinforcing strip is moved, via the applicator head (50), to a predetermined sealing location. At this point, the primary web and the reinforcing strip should be appropriately aligned to create the reinforced area. Consequently, in step 130 the reinforcing strip is attached or laminated to the primary web. Following this laminating step, the primary web is advanced to an output buffering stage. Again, this causes the system to return to its waiting state where it looks for further signals related to needs at the output buffer. Naturally, each of these steps require the coordination of various components within the various devices. However, the general operation will be consistent.

The above referenced flow diagram relates to the processing of a single strip as carried through the cutting and laminating apparatus. It should be clear from the foregoing description that the cutting and laminating apparatus is capable of cutting a single reinforcing strip while concurrently laminating a reinforcing strip to the primary web. Additionally, material is often being fed or withdrawn in appropriate amounts between various actions. For example, while the sheared strip is being transferred from the area adjacent the cross web shear (40) to the area adjacent the laminator (20), material from both the primary supply web (12) and the secondary supply web (14) is being appropriately fed and positioned for the next operation.

As previously mentioned, cross web shear (40) produces reinforcing strips very accurately and repeatedly. Consequently, the reinforced areas themselves can be very well controlled. Additionally, by using precise control motor (82) to control the position of applicator head (50), along with very precise drive rollers (24) for moving primary web (12), very precise placement of reinforcing strips can be obtained. This allows for very repeatable pitch distances to be achieved between the subsequent reinforcing strips.

Those skilled in the art will further appreciate that the present invention may be embodied in other specific forms without departing from the spirit or central attributes thereof. In that the foregoing description of the present invention discloses only exemplary embodiments thereof, it is to be understood that other variations are contemplated as being within the scope of

the present invention. Accordingly, the present invention is not limited in the particular embodiments which have been described in detail therein. Rather, reference should be made to the appended claims as indicative of the scope and content of the present invention.

What Is Claimed:

1. A laminating device for providing a reinforced region of material supply web, comprising:
 - a primary feeding mechanism cooperating with a primary supply web for advancing a predetermined length of the primary supply web;
 - a secondary feeding mechanism for advancing a predetermined length of secondary web;
 - a cross web shearing apparatus positioned downstream from the secondary feeding mechanism for receiving the predetermined length of the secondary web, the cross web shearing apparatus including a shear blade positioned substantially perpendicular to the secondary material web and movable through a cutting motion to cause a reinforcing strip to be sheared from the secondary web;
 - a handling drive positioned adjacent the shearing apparatus for receiving the reinforcing strip and moving it to a sealing location adjacent the base primary web; and
 - a laminating device located proximate the handling manifold for sealing the reinforcing strip to the base material web.
2. The laminating device of claim 1 wherein the cross web shearing apparatus further comprises a support blade positioned substantially perpendicular to the shear blade and in a cutting relationship therewith such that the shear blade and the support blade cause the hearing of the reinforcing strip.
3. The laminating device of claim 1 wherein the primary feeding mechanism is a driven primary feed roller controlled to feed the predetermined amount of the primary web.
4. The laminating device of claim 1 wherein the secondary feeding mechanism is a driven secondary feed roller controlled to feed the predetermined amount of the secondary web.

5. The laminating device of claim 1 wherein the primary web is oriented polypropylene.

6. The laminating device of claim 1 wherein the primary web is metalized oriented polypropylene.

7. The laminating device of claim 1 wherein the handling device is a vacuum applicator manifold using a vacuum signal to hold the reinforcing strip.

8. The laminating device of claim 1 wherein the handling device comprises a plurality of applicator manifolds each using a vacuum signal to hold the reinforcing strip.

9. The laminating device of claim 8 wherein the plurality of applicator manifolds are attached to a rotation block, wherein the rotation block is rotatable about a central axis to appropriately position the plurality of applicator manifolds.

10. The laminating device of claim 1 further comprising a holding clamp positioned adjacent the cross web shear and the handling device, such that the holding claim will hold the secondary web against the handling device prior to shearing the reinforcing strip.

11. The laminating device of claim 10 wherein the holding clamp includes a holding tab movable between a feeding position and a holding position, wherein the holding tab allows the secondary web to be feed between the holding clamp and the handling device when the holding tab is in the feeding position while the holding tab holds the secondary web against the holding mechanism when the holding tab is in the holding position.

12. The laminating device of claim 1 wherein the shear blade is curved and the cutting motion is a rocking motion.

13. The laminating device of claim 12 wherein the shear blade includes a plurality of cam tracks that cooperate with plurality of the cam followers to cause the rocking motion.

14. The laminating device of claim 13 wherein at least one of the cam followers are attached to a cam follower framework, wherein movement of the cam follower framework generates the cutting motion.

5

15. The laminating device of claim 14 wherein the cam follower framework is moved is a substantially linear path.

16. The laminating device of claim 2 wherein the shear blade includes a plurality of
10 cam tracks that cooperate with plurality of the cam followers to cause the cutting motion to be a rocking motion, and wherein the plurality of cam followers includes a cam pin attached to the blade and cooperating with a cam track attached to the support blade to create the rocking motion.

15 17. The laminating device of claim 16 wherein the shear blade includes a plurality of cam tracks that cooperate with a plurality cam followers which attached to a cam follower framework, wherein movement of the cam follower framework generates the cutting motion.

20 18. The laminating device of claim 17 wherein a cam framework actuator causes movement of the cam follower framework resulting in the rocking motion of the rocking motion.

19. The laminating device of claim 2 wherein the shear blade extends only a predetermined distance below the support blade at any time.

25 20. A cross web shear device for accurately shearing predetermined strips of material from a supply web traveling in a web direction, the cross web shear device comprising:
a shear blade positioned substantially perpendicular to the supply web and perpendicular to the web direction, the shear blade having at least one cam track therein;
a support blade positioned substantially parallel with the supply web and perpendicular to
30 the web direction; and

5 a blade actuator having at least one cam pin, the at least one cam pin cooperating with the
at least one cam track to cause the blade to move through a cutting motion when
the blade actuator is actuated, the support blade and the shear blade positioned in
a cutting relationship with one another to shear the predetermined strip of material
when the cutting blade moves through its cutting motion.

10 21. The cross web shear of claim 20 further comprising a cam framework attached to
the support blade and a cam pin attached to the shear blade for further controlling the motion of
the shear blade.

22. The cross web shear of claim 20 wherein the shear blade extends only a
predetermined distance below the support blade at any time.

15 23. The cross web shear of claim 20 wherein the shear blade is curved and the cutting
motion is a rocking motion.

20 24. The cross web shear of claim 21 wherein the at least one cam track includes a first
cam track and a second cam track, and the at least one cam pin includes a first cam pin and a
second cam pin, both the first cam pin and the second cam pin movable along a predetermined
path by the actuator wherein movement of the first cam pin and the second cam pin along the
predetermined path causes the blade to move through its cutting motion.

25 24. The cross web shear of claim 23 wherein the cam framework includes a
framework cam track cooperating with the cam pin attached to the shear blade, and wherein the
cutting motion is a rocking motion controlled by the configuration of the first cam track, the
second cam track, and the framework cam track.

25. A method for producing a reinforced web of material, comprising

(a) providing a primary web of material

30 (b) providing a secondary web of material, the secondary web of material making up
a reinforcing material for attachment to the primary web;

- (c) cross web shearing a strip of the secondary web in a direction perpendicular to a direction of travel for the secondary web;
- (d) positioning the sheared strip of the secondary web adjacent the primary web such that the sheared strip is substantially perpendicular to a direction of travel for the primary web; and
- (e) attaching the sheared strip to the primary web.

26. The method of claim 25 where the step of attaching the sheared strip comprises heat laminating the sheared strip to the primary web.

27. The method of claim 26 wherein the cross web shearing comprises feeding the secondary web material to a predetermined position within a cross web shear apparatus, holding the secondary web material in the predetermined position, and actuating a shear blade to travel through a predetermined shear blade motion.

28. The method of claim 27 wherein the predetermined shear blade motion is a rocking motion.

29. The method of claim 28 wherein the step of actuating the shear blade includes the steps of moving a plurality of cam pins through a predetermined path, the cam pins cooperating with the shear blade to cause the blade to move through its rocking motion.

30. The method of claim 29 wherein the cam pins cooperate with a plurality of cam tracks in the shear blade such that the step of actuating the shear blade includes moving the cam pins causes them to travel along the cam tracks.

31. The method of claim 25 wherein the step of positioning includes securing the sheared strip to a positioning device and moving the positioning device to the position adjacent the primary web.

32. The method of claim 31 wherein the step of securing the shear strip involves creating a vacuum signal within the positioning device, thus creating a vacuum seal between the positioning device and the sheared strip.

5 33. An apparatus for producing a supply of material in a web format having reinforcements in predetermined locations, comprising:

a primary supply feed roller coupled to a primary web to move the primary web in a predetermined manner;

10 a secondary supply feed roller coupled to a secondary web to move the secondary web in a predetermined manner;

15 a cross web shear device having a shear blade and a support blade, the cross web shear device positioned to receive the secondary supply web at a cutting position between the shear blade and the support blade, the cross web shear further having a blade actuator for moving the blade through a cutting motion after the secondary supply web has been positioned at the cutting position resulting in a reinforcing strip to be sheared from the secondary web;

20 a movable applicator having an applicator manifold positionable in a cutting position adjacent the cross web shear such that the secondary web extends adjacent a holding surface of the applicator manifold when the secondary web is in the cutting position, the applicator manifold having a plurality of vacuum apertures in the holding surface to create a vacuum seal between the secondary web and the holding surface when the secondary web is in the cutting position, the movable applicator movable between cutting position and a delivery position allowing movement of the reinforcing strip to an attachment location; and

25 an attachment device positioned adjacent the primary web and adjacent the applicator delivery position, wherein the reinforcing strip can be attached to the primary web at a reinforcing location by the attachment device cooperating with the applicator.

30 34. The apparatus of claim 33 wherein the attachment device is a laminating device having a heating element to attach the reinforcing strip via a heat seal.

35. The apparatus of claim 33 wherein the cutting motion is a rocking motion.

36. The apparatus of claim 35 wherein the rocking motion is created by a plurality of cam tracks in the cutting blade and a plurality of cam pins coupled to the blade actuator.

5

device efficiently produces the required reinforcing strips and then laminates them to the web. In order to efficiently and accurately produce these reinforcing strips, a cross web shear is utilized which is capable of cutting required reinforcing strips from the fairly large web of reinforcing material in an accurate manner. Once cut, a holding and positioning device is capable of grabbing onto the reinforcing strip and appropriately positioning it next to the primary material web. A separate laminator can then attach this reinforcing strip to the web at a desired location.

307-60086500

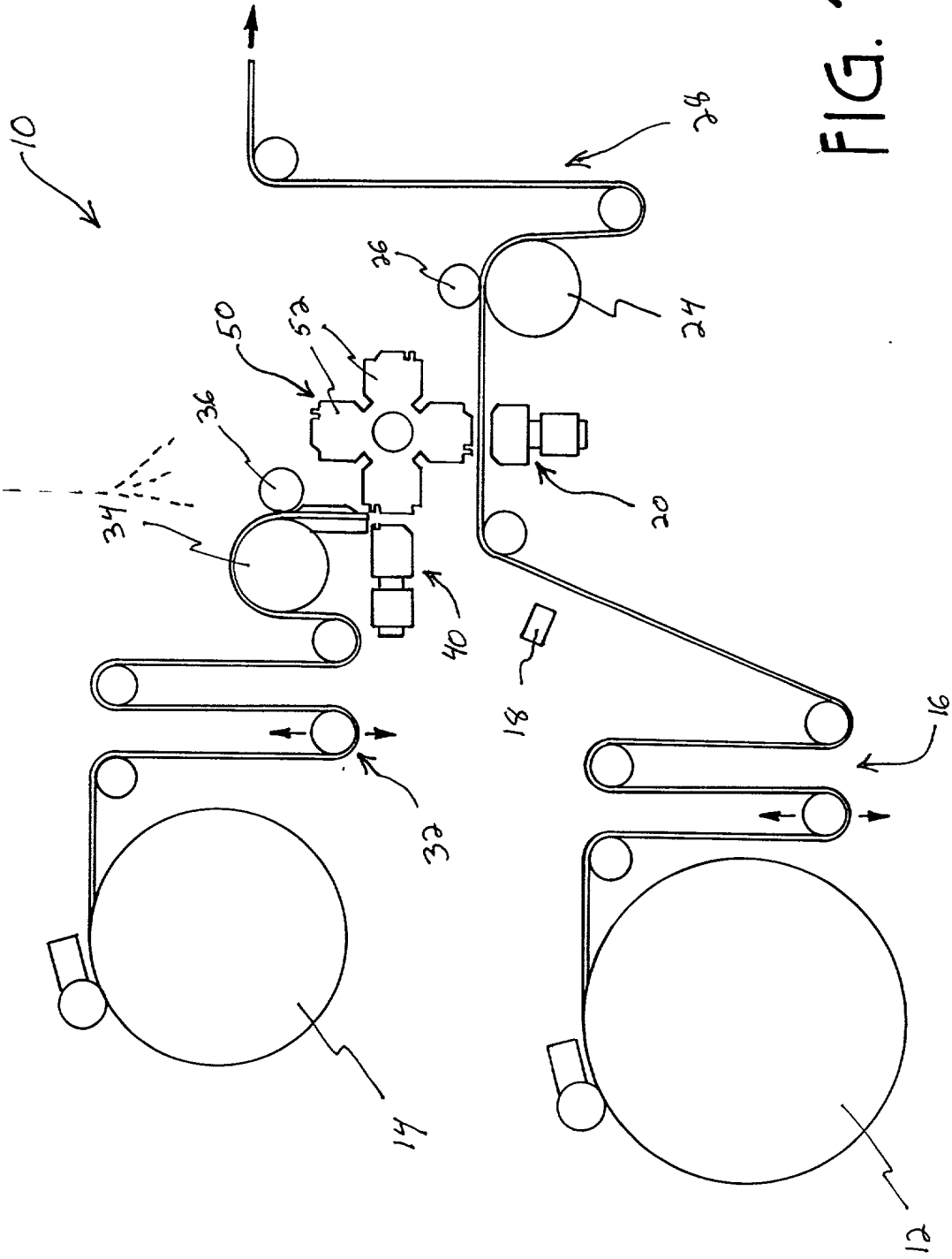


FIG. 1

009207 60086960

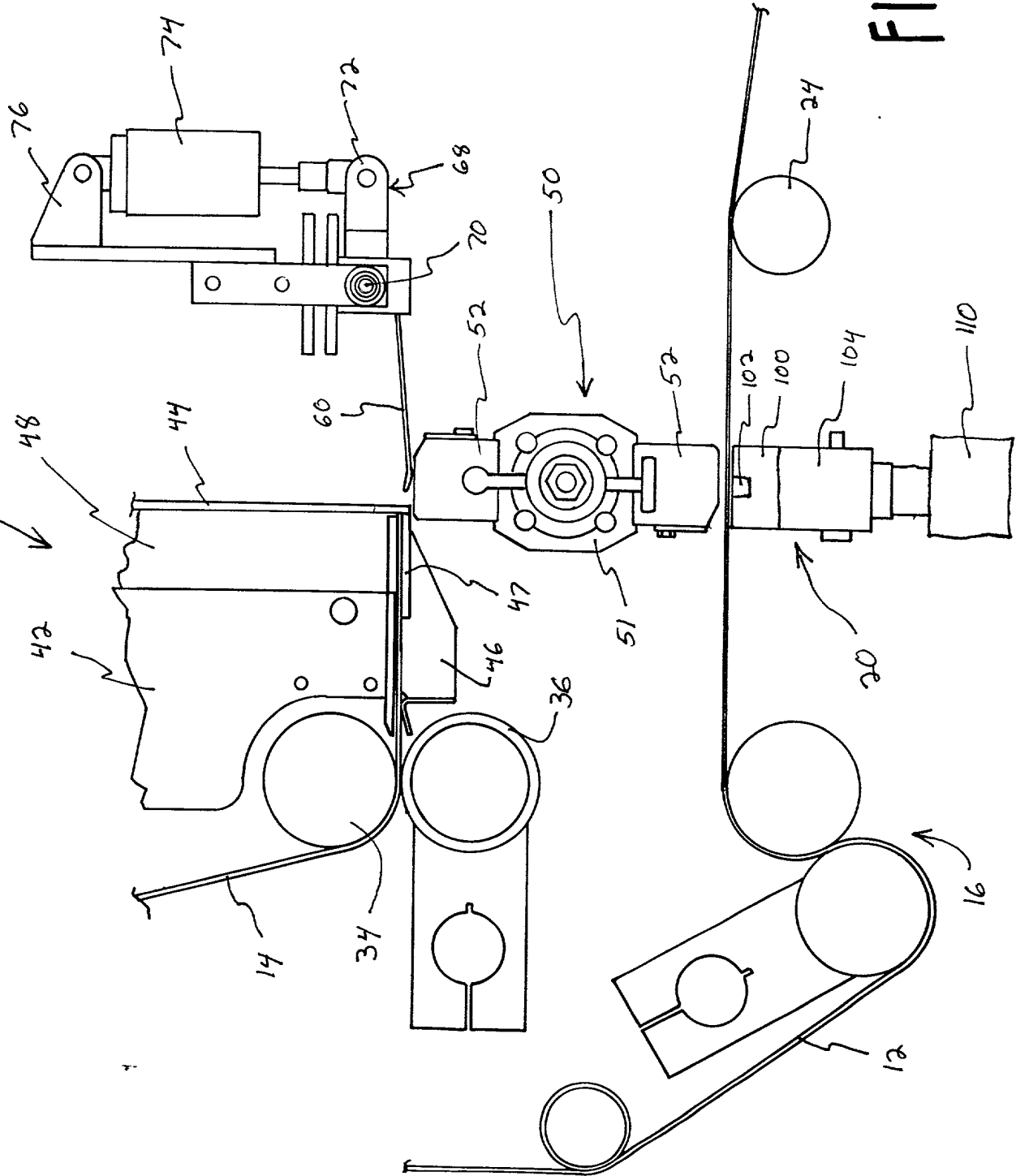
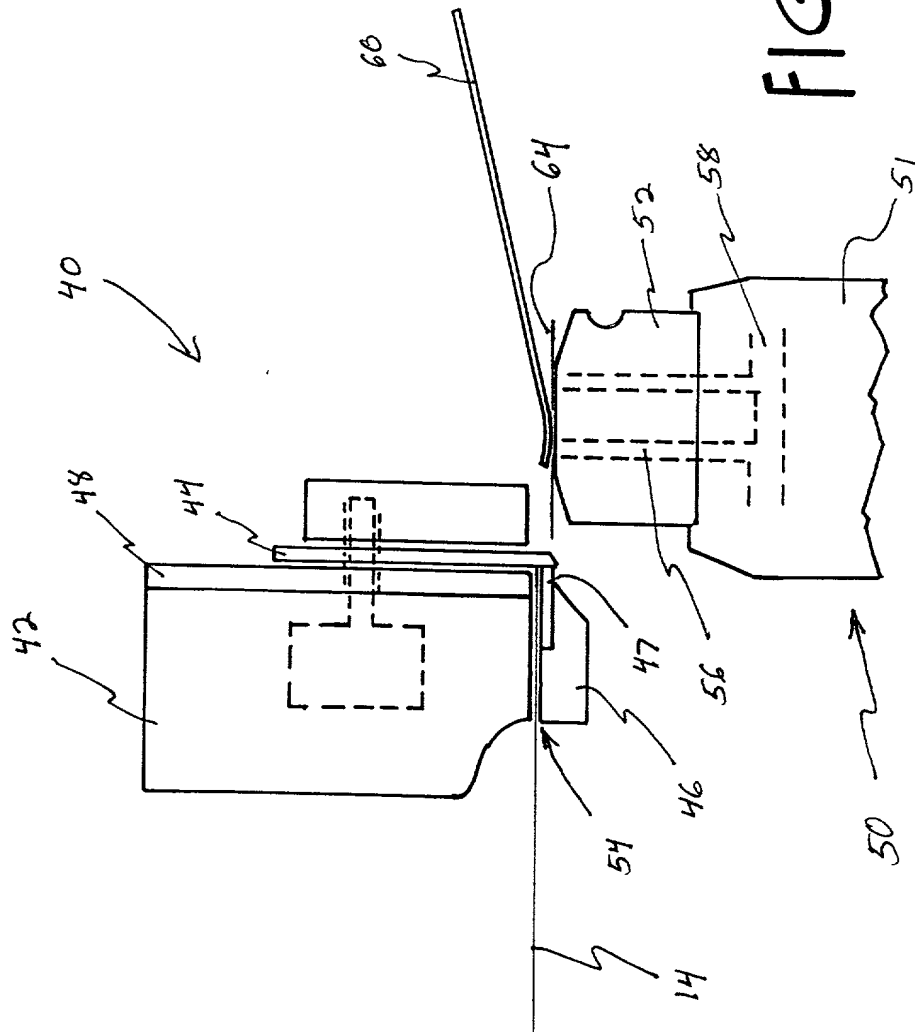


FIG. 2



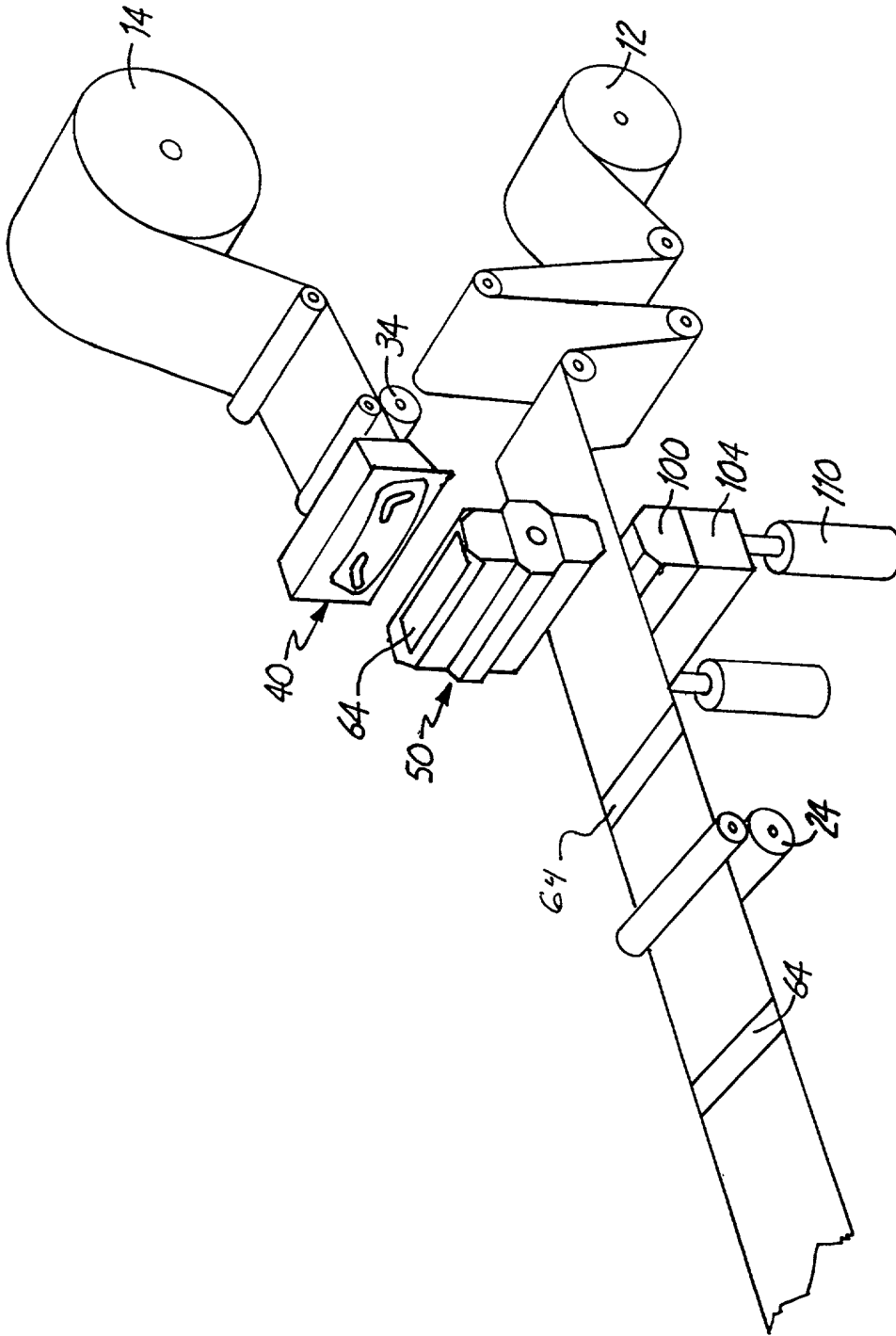


FIG. 4

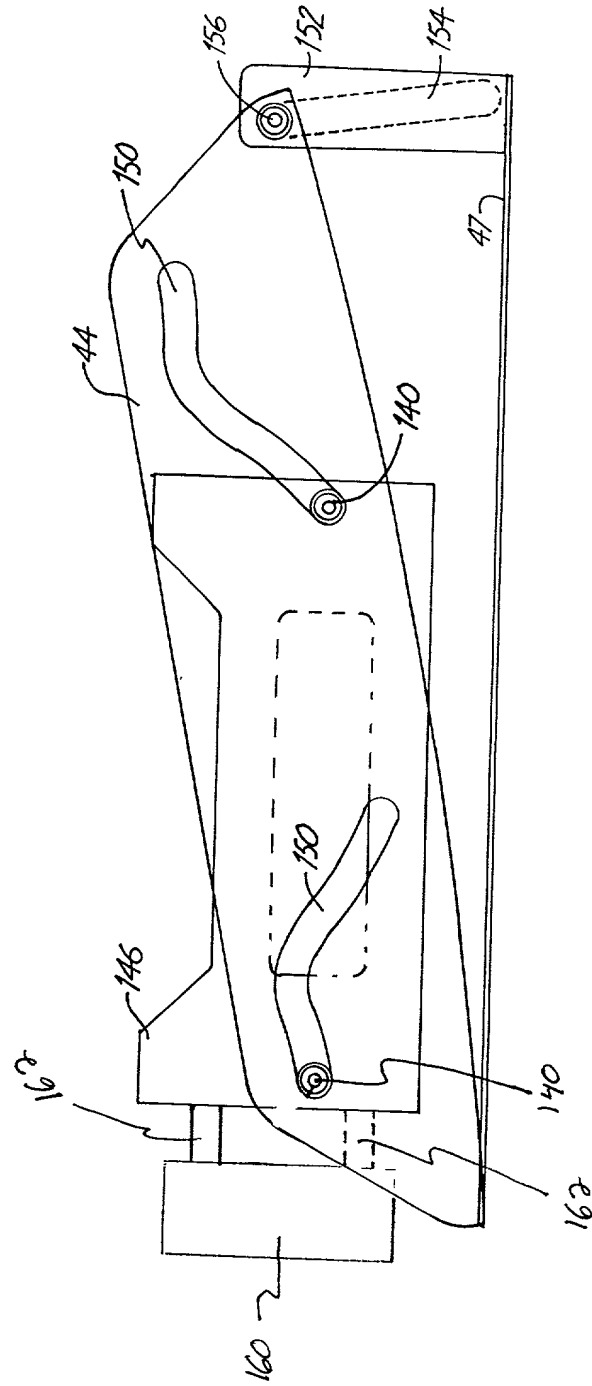


FIG. 5A

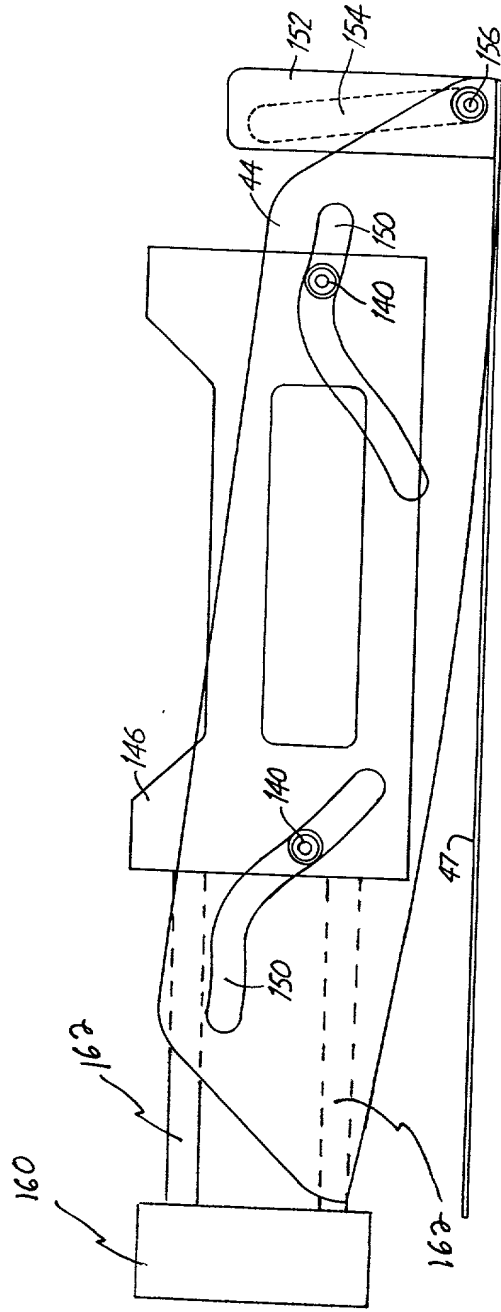


FIG. 5D

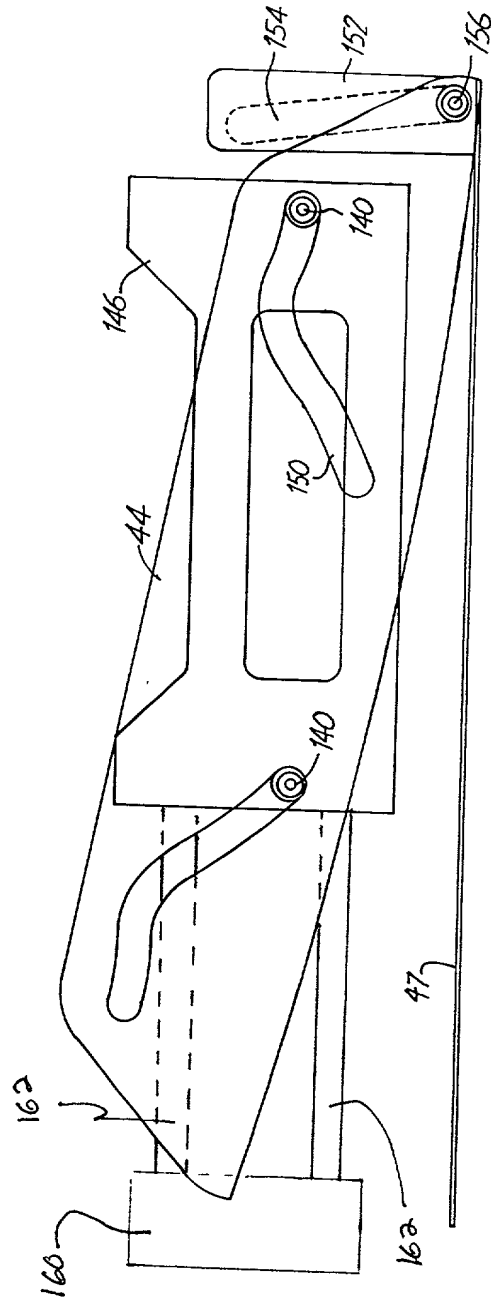


FIG. 5E

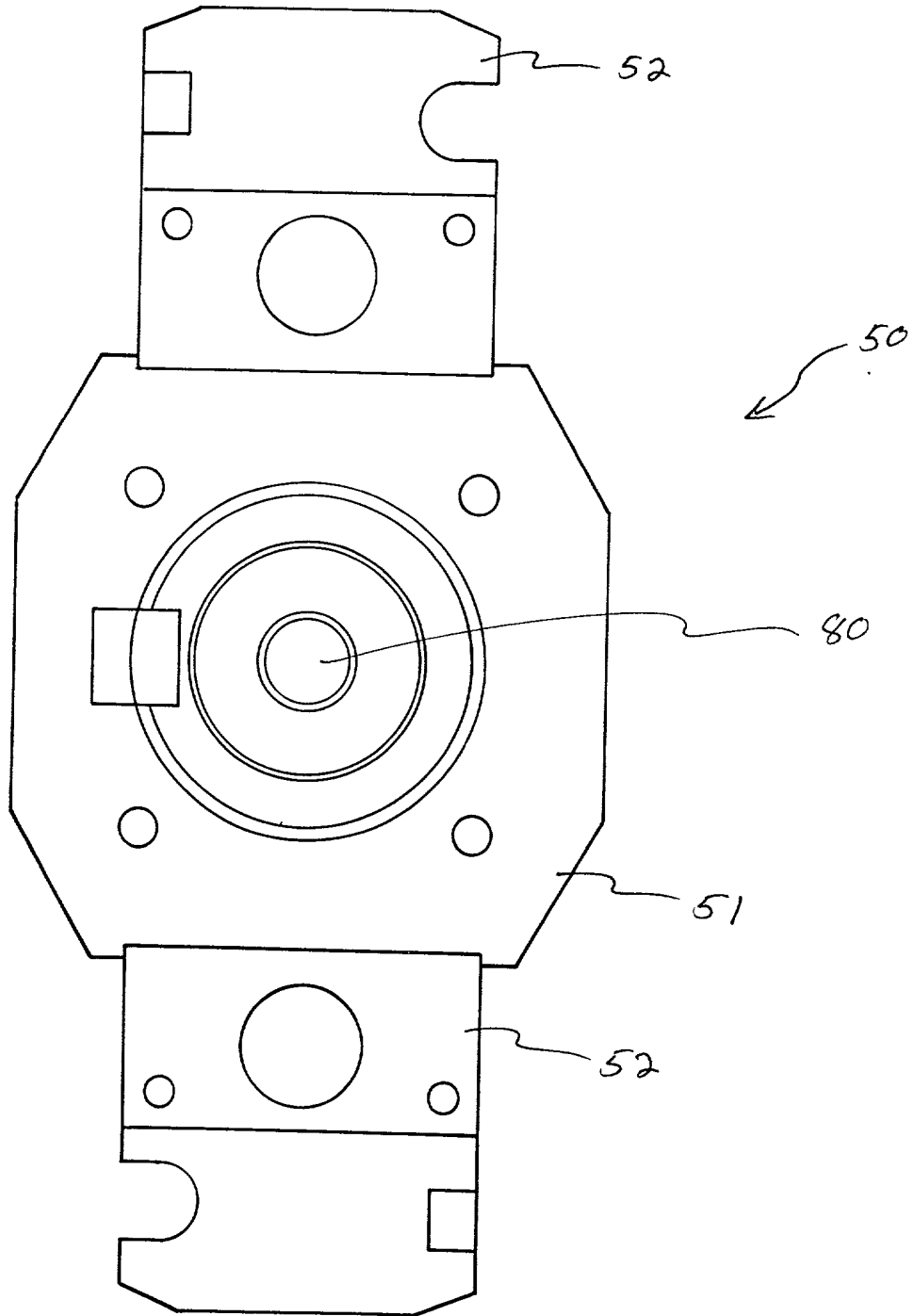
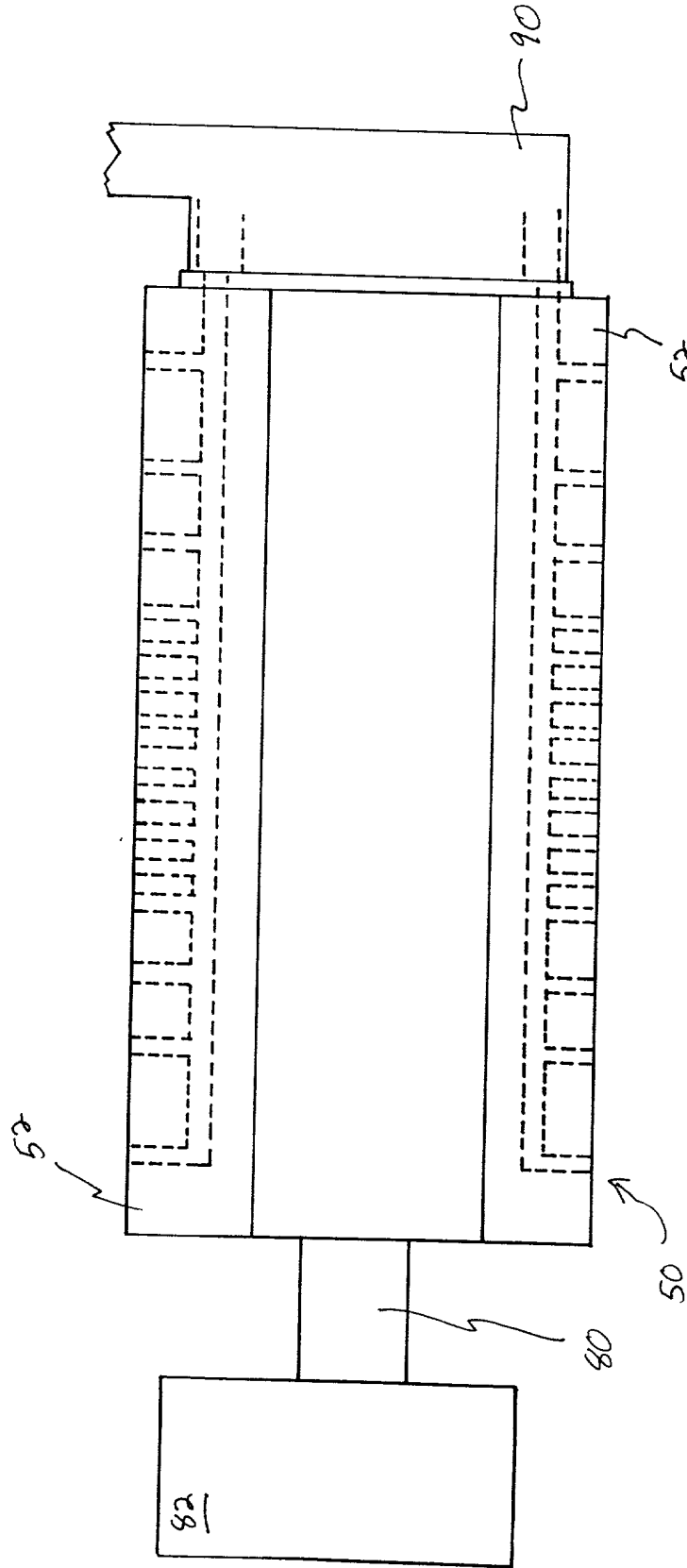


FIG. 6



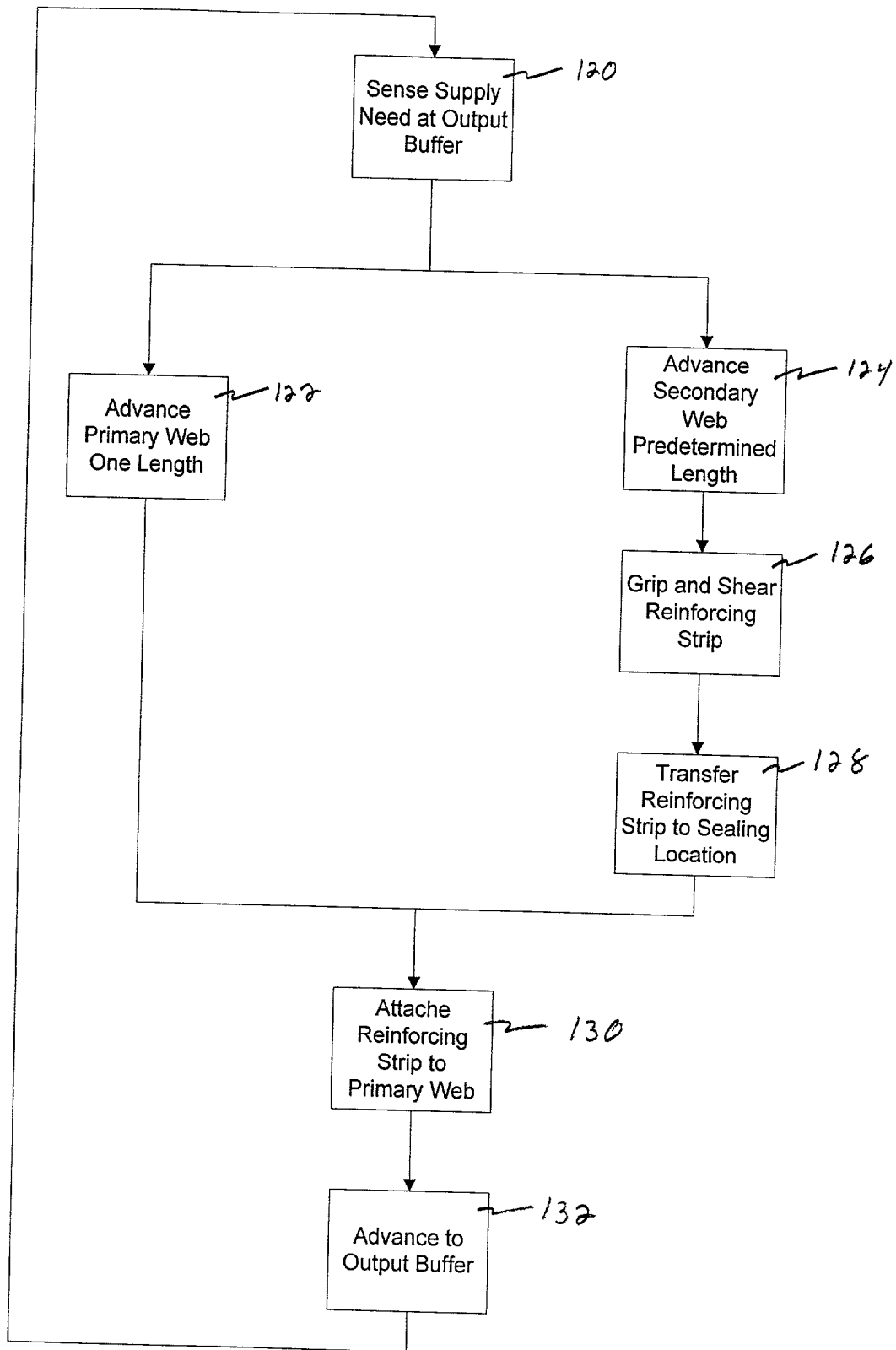


FIG. 8

JOINT INVENTORS

DECLARATION FOR PATENT APPLICATION AND POWER OF ATTORNEY

As the below named inventors, we hereby declare that:

Our residence, post office address and citizenship are as stated below next to our names.

We believe we are the original, first and joint inventors of the subject matter which is claimed and for which a patent is sought on the invention entitled: CUTTING AND LAMINATING APPARATUS FOR PRODUCING REINFORCED WEB, the specification of which is submitted herewith and which may be identified in the United States Patent and Trademark Office by Serial No. _____ filed _____.

We hereby state that we have reviewed and understand the contents of the above identified specification, including the claims.

We acknowledge the duty to disclose information which is material to the examination of this application in accordance with Title 37, Code of Federal Regulations, Sec. 1.56(a).

POWER OF ATTORNEY: We hereby appoint the following attorneys to prosecute this application and transact all business in the Patent and Trademark Office connected therewith:

OPPENHEIMER WOLFF & DONNELLY LLP

Craig J. Lervick, Reg. No. 35,244

Harold D. Jastram, Reg. No. 19,777

Alan Kamrath, Reg. No. 28,227

David J. Mckinley, Reg. No. 42,867

Daniel G. Chapik, Reg. No. 43,424

W. Glenn Edwards, Reg. No. 44,426

Cyrus A. Morton, Reg. No. 44,954

Send correspondence to: Craig J. Lervick, Oppenheimer Wolff & Donnelly LLP, Plaza VII, Suite 3400, 45 South Seventh Street, Minneapolis, MN 55402. Direct telephone calls to Craig J. Lervick, Esq. at (612) 607-7387.

We declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Inventor's Signature _____

Inventor's Signature _____

Post Office Address:

TC2: 489269 v01 10/25/2000